

Date: Friday, 14/11/2008 10:20:59 AM
 User: Julie Dawson

Process Sheet

SPLPT

| | | | | | | |
|---|---------------------------------------|-----------------------|------------------|----------------|-----|------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : MOUNTING LUG | | |
| Job Number | : 43444 | | | | | |
| Estimate Number | : 10255 | | | | | |
| P.O. Number | : | | | | | |
| This Issue | : 14/11/2008 | S.O. No. : | Part Number | : D22301 | | |
| Prsht Rev. | : NC | | Drawing Number | : D2230 REV F | | |
| First Issue | : / / | Type : MACHINED PARTS | Project Number | : N/A | | |
| Previous Run | : 41819 | | Drawing Revision | : F | | |
| Written By | : | | Material | : | | |
| Checked & Approved By | : JUO 08.11.14 | | Due Date | : 10/12/2008 | | |
| Comment | : | | Qty: | 200 | Um: | Each |
| : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC | | | | | | |

Additional Product

| | | |
|---|---|---|
| Job Number: |  | |
| Seq. #: | Machine Or Operation: | Description : |
| 1.0 | D2423 | Lug Extrusion  |
| Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s) Lug Extrusion D2423 Extrusion Batch: 43722 | | |
| 2.0 | BAND SAW | BAND SAW  Cut @ 4 meters |
| Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch: | | |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1  issue R10'. 7604 meters |
| Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling | | |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE  rec'd + inspect attached C of C |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 5.0 | QC2 | SECOND CHECK  S |
| Comment: SECOND CHECK | | |

RG 12/18 101

counter

S 08/10/18 (x101)

J

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 43444

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(101)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fix 07/12/18

7.0 QC5

INSPECT WORK TO CURRENT STEP



Counter

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



M109996



(101X)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 8-00

OVEN TEMPERATURE: 320

FINISH TIME: 8-30

m-f 08/12/19

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(101)

Comment: INSPECT POWDER COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Fix 08/12/19

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/12/23

11.0 QC21

FINAL INSPECTION/W/O RELEASE



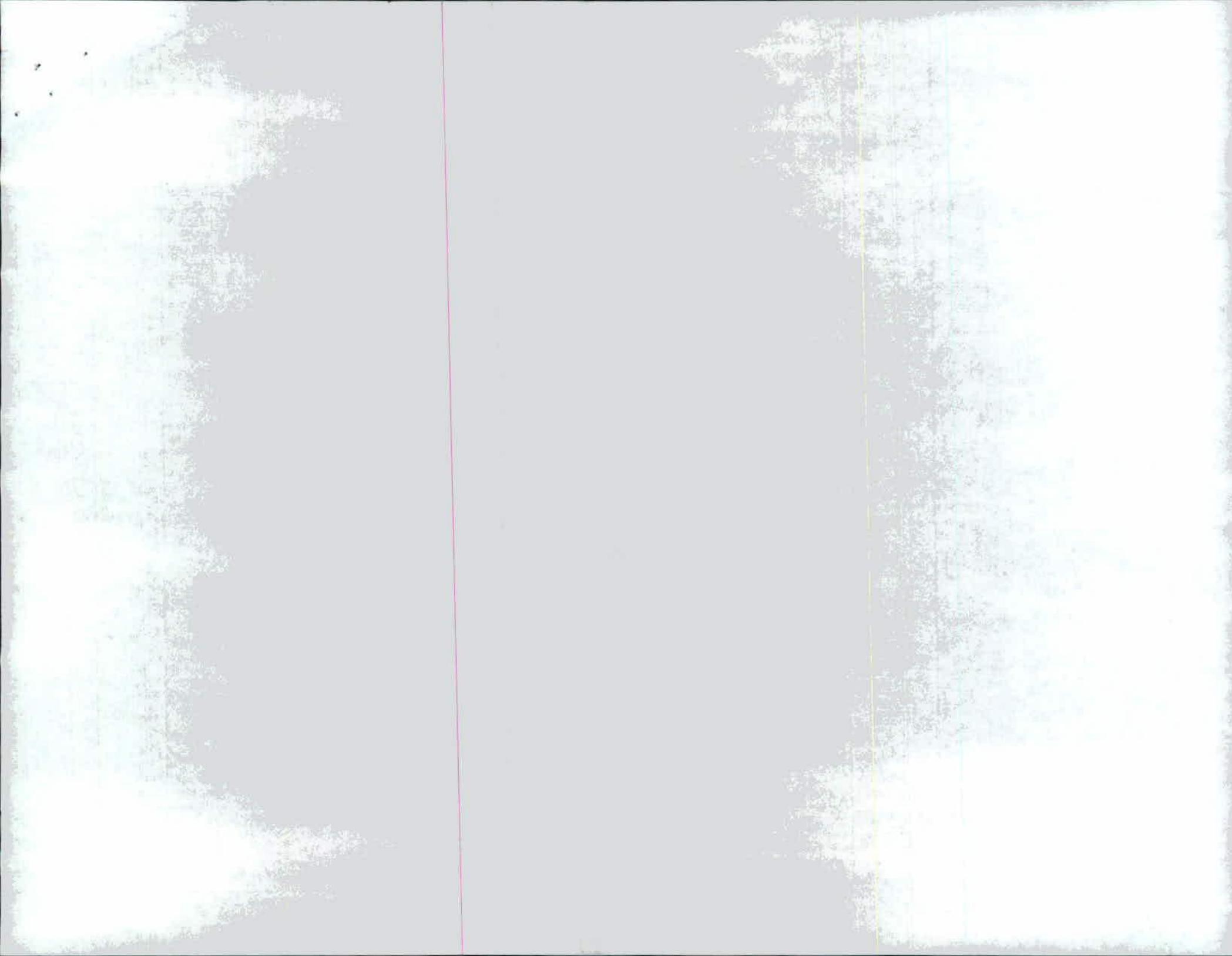
(101)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

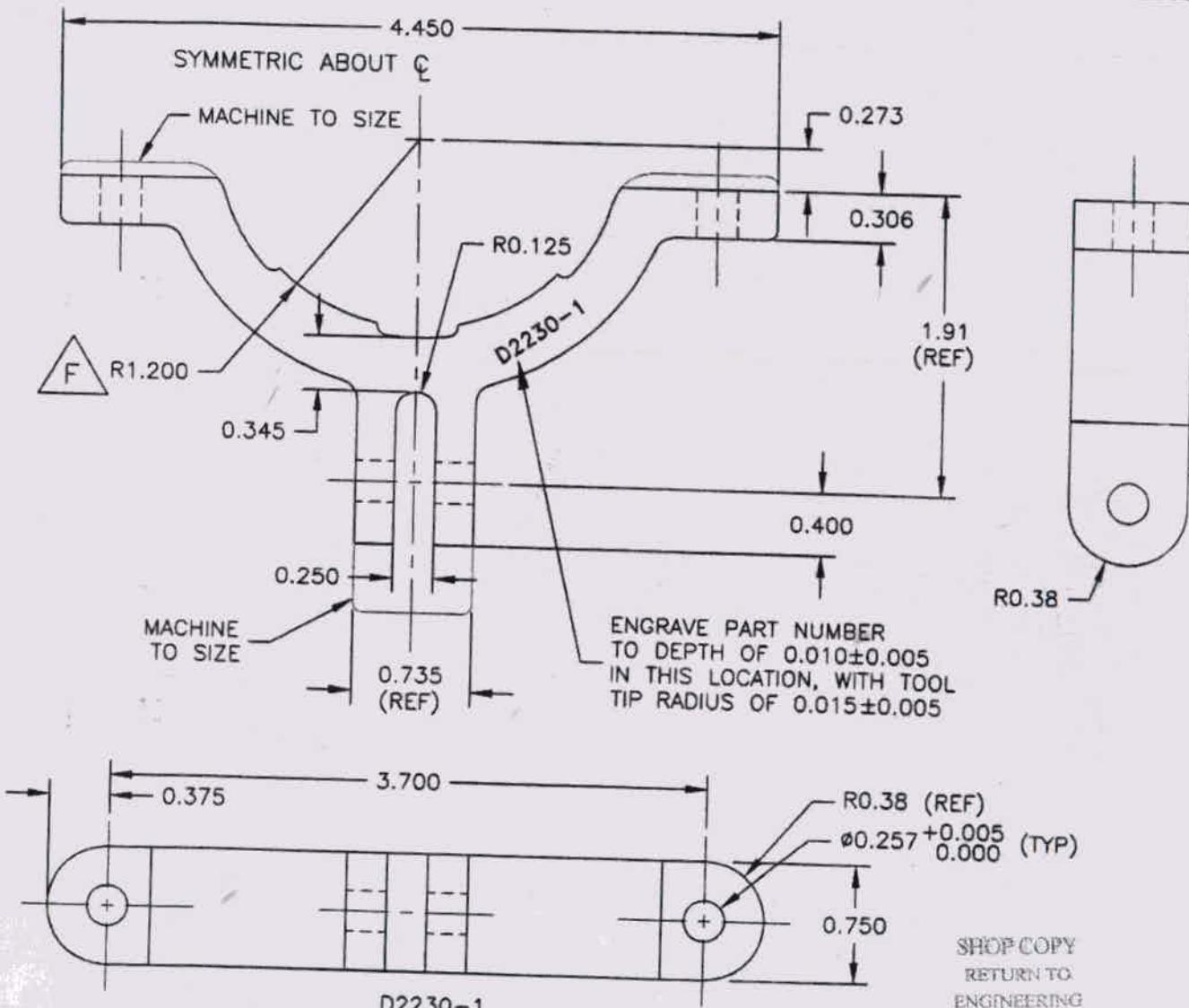


MF 08-12-23



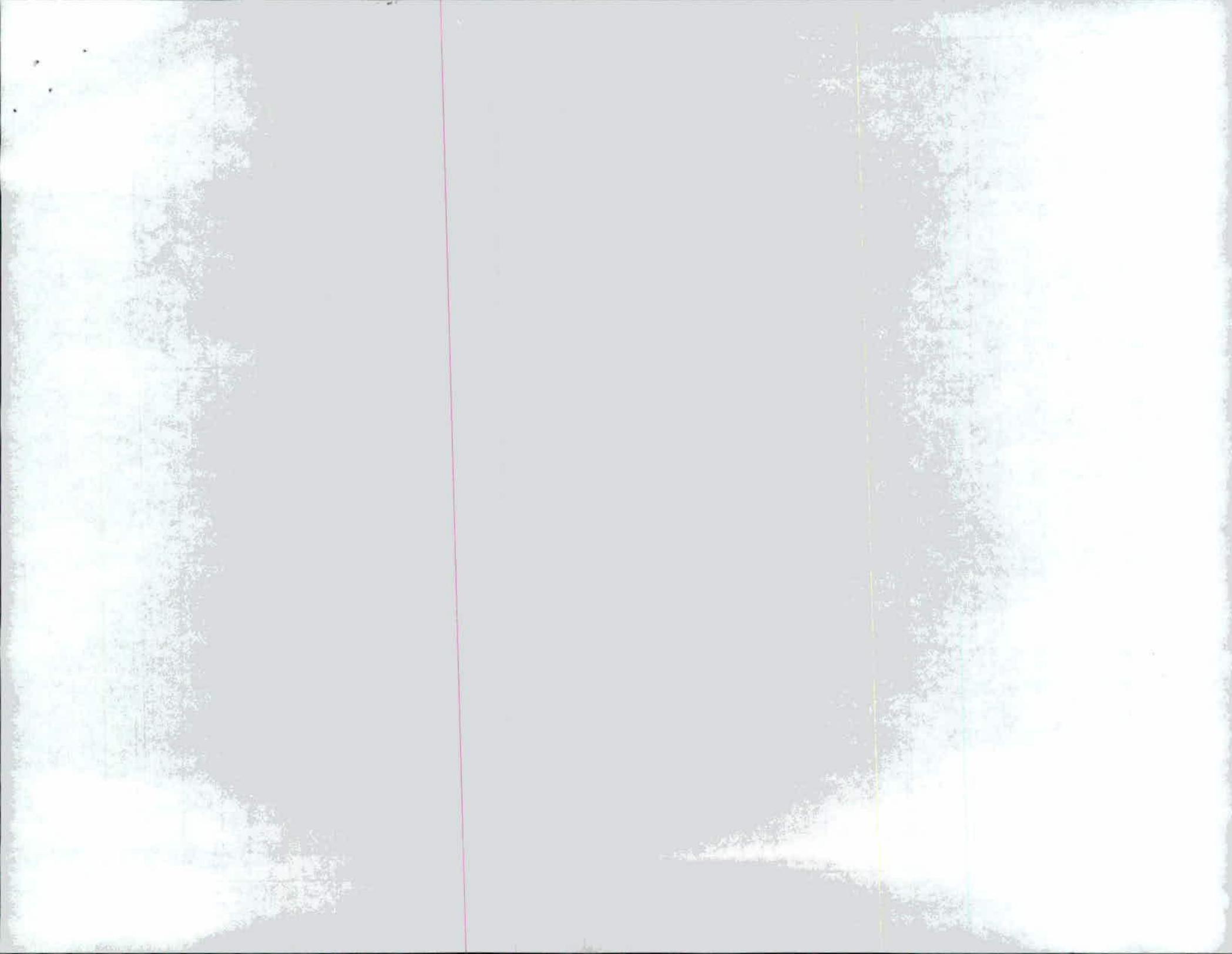
DART

| | | |
|----------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2230 |
| DATE | | REV. F SHEET 1 OF 2 |
| 99.12.13 | | TITLE MOUNTING LUG |
| C | 94.03.30 | SCALE 1:1 |
| D | 95.01.04 | |
| E | 95.01.04 | |
| F | 99.12.13 | REDESIGN; R1.200 WAS R1.100 |

RELEASED
19-12-21 DS

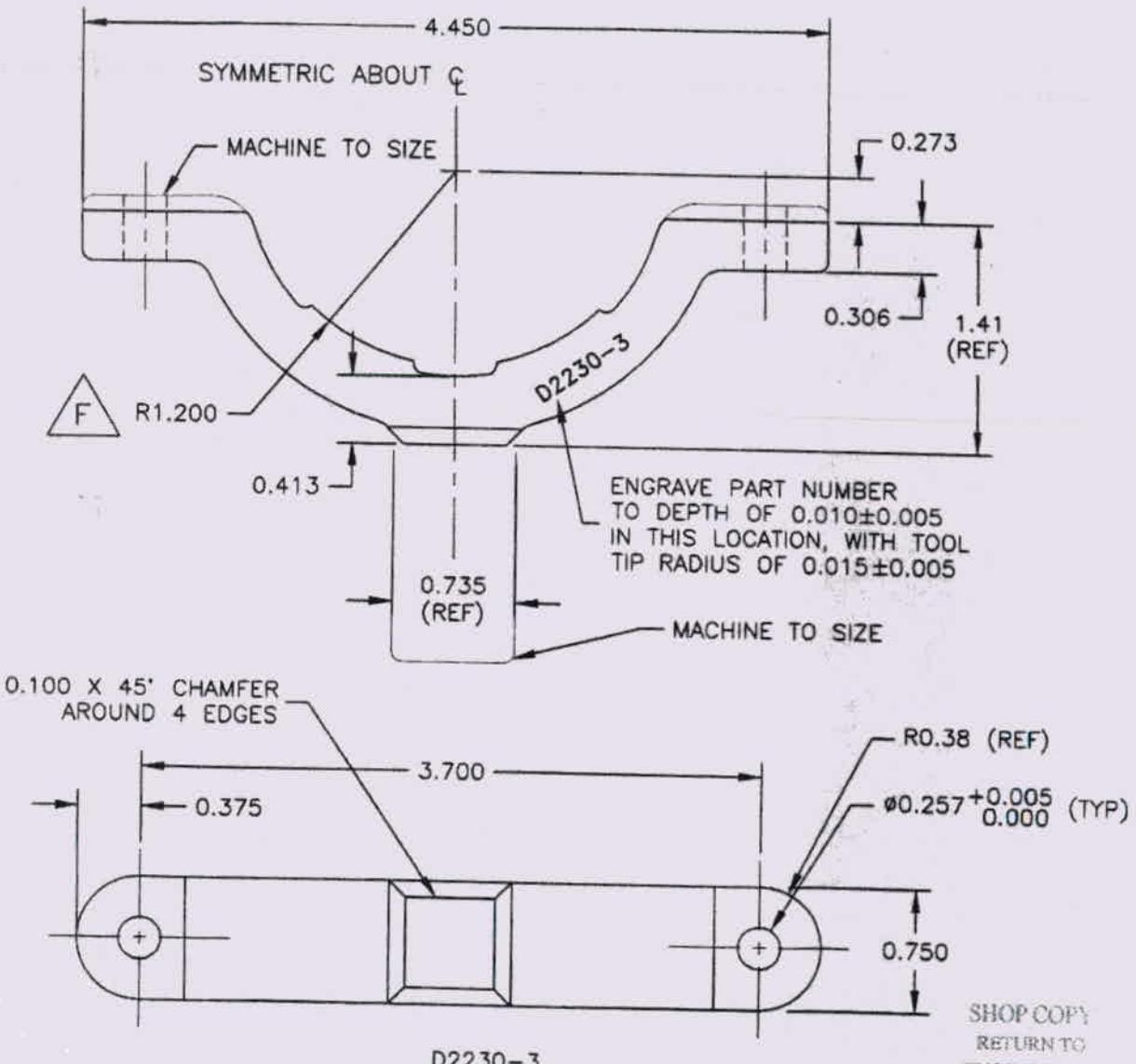
MAKE FROM EXTRUSION D2423
 BREAK ALL EDGES 0.000-0.015
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 WITHOUT NOTICE
 WORK ORDER
 NO. 43444



DART

| | | |
|---------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2230 |
| DATE | | REV. F SHEET 2 OF 2 TITLE MOUNTING LUG SCALE 1:1 |

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
NO. 213444
WORK ORDER



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

| <u>QUANTITY</u> | <u>PART NUMBER</u> | <u>PART NAME</u> | <u>P.O. NUMBER</u> |
|-----------------|--------------------|------------------|--------------------|
| 101 | D2230-1 | Mounting lug | 7604 |

MATERIAL supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in blue ink, appearing to read "Shig Walz".

A handwritten date in blue ink, reading "Oct 21/08".

Vankleek Hill, December 18, 2008

